

Work Order ID 53060

October 22, 2009 1:59:19 PM



Page 1

Item ID: D130-780-042

Accept



Setup

Start



Revision ID: B

Stop



Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run

Start



Approvals:

Process Plan: *[Signature]*

Date: 09/10/22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D130-780

B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-042 CHG 003

8.06/23

[Signature] for BG 10/07/22

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

45 10-07-14

120

0.00



Small Fab

Memo

0.00

Small Fab

-Assemble as per dwg D3188.
-use door to transfer drill hole location.
-Install inserts

45 10-07-22

Work Order ID 53060

October 22, 2009 1:59:19 PM

Page 2

Item ID: D130-780-042

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Start

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Stop

Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run

Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/12/22

X

140

Wing Walk as per dwg QSI005 4.4 Batch 114432

0.00



HandFinish

Memo

0.00

Hand Finishing

TOP SURFACE OF POD

8T

10-07-22

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

nd

10 07 22 (1)

Work Order ID 53060

October 22, 2009 1:59:19 PM

Page 3

Item ID: D130-780-042

Accept

Setup

Start

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Stop

Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run

Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

180

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D130-780-042

Location:

PPP Rev:

10-7-22 18

Pro →

10-7-23 SP

Dart Aerospace Ltd

W/O: 53060

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/7/23	# 100	Perm. Change Parts missing of Parts list to w/o. ADD D3515-5 B <u>56503</u> qty x3 to kit S 10/1/23 ADD MS24694554 M <u>11339</u> qty x6 per kit S 10/1/23	S	10-7-23			S 10/4/23
10/7/23	# 100	update w/o + Bom. ADD copy of updated Bom as Ref. Qty is wrong for MS810423 should be (22) per kit Qty is wrong for NAS1145D0363 should be (x14) per kit	E	10.07.23			S 10/4/23

Part No: D130-780-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53060

October 22, 2009 1:59:19 PM

Page 4

Item ID: D130-780-042

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Setup

Start

Revision ID: B

Stop

Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run

Start

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/26 *[Signature]*
MK
10-7-23

Picklist Print

October 22, 2009 1:59:24 PM

Page 1

Work Order ID: 53060

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH



Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D130-780-044RevA		Manufactured	No			110	Each	0.0000	1.0000			
						B 53022					RT 10-07-13	
Spacepod Door Assembly, RH												
D3188-2MRevE		Manufactured	No			110	Each	1.0000	1.0000			
						358924					RT 10-07-13	
SPACEPOD BODY RH												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

CA

1

46180A

1

AKS4-1032-130

AKS4-1032-130

Purchased

No

110

Each

1.0000

28.0000



Inserts

m 114723

RT 10-07-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

6087

1

D3837-4RevB

Manufactured

No

110

Each

5.0000

1.0000



Decal

10-7-23 sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

46233

5

Picklist Print

October 22, 2009 1:59:24 PM

Page 2

Work Order ID: 53060

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH





Comments:

Start Date: 21/10/2009

Start Qty: 1.00

Required Date: 04/11/2009

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2237RevD1  Striker Plate		Manufactured	No			110	Each	81.0000	2.0000		BT	10-07-14
				<u>Warehouse</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				<u>Location</u>								
				Main Warehouse								
				ST			5					
				46162			5					
				Main Warehouse								
				ST022			76					
				50348			21					
				52327			55					
MS20426AD4-5  Rivet		Purchased	No			110	Each	7,910.000	4.0000		BT	10-07-14
				<u>Warehouse</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				<u>Location</u>								
				Main Warehouse								
				ST			7910					
				4067			1097					
				6733			1831					
				6874			4982					

October 22, 2009 1:59:24 PM

Shop Packet Print

Page 2

Picklist Print

October 22, 2009 1:59:24 PM

Page 3

Work Order ID: 53060

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH





Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3538-1RevA  Hinge Bracket		Manufactured	No			110	Each	24.0000	2.0000	 25	10-07-14	
355012												
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST				14				
				48197				14				
				Main Warehouse								
				ST111				10				
				50336				10				
AN526-832R24  Screw		Purchased	No			110	Each	201.0000	4.0000	 25	10-07-14	
B110129												
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST				201				
				16895				201				

October 22, 2009 1:59:24 PM

Shop Packet Print

Page 3

Picklist Print

October 22, 2009 1:59:24 PM

Page 4

Work Order ID: 53060

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH



Comments:

Start Date: 21/10/2009

Start Qty: 1.00

Required Date: 04/11/2009

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149DN832J  WASHER		Purchased	No			110	Each	375.0000	4.0000		ST	10-07-14

m 114883 x4

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	375	
111193	3	
111359	72	
112385	300	

MS21042L08



Nut

Purchased

No

110

Each

407.0000

4.0000

m 114330 x4

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	407	
110002	24	
111889	51	
112243	47	
112492	85	
112612	100	
112794	100	

ST 10-07-14

October 22, 2009 1:59:24 PM

Shop Packet Print

Page 4

Picklist Print

October 22, 2009 1:59:24 PM

Page 5

Work Order ID: 53060

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH




Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3815-041RevA  Web Assembly		Manufactured	No			160	Each	7.0000	2.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>45729</div> <div>46356</div> <div>Loc Qty</div> <div>7</div> <div>1</div> <div>6</div> <div>Loc Code</div>												
D3837-1RevB  Decal		Manufactured	No			160	Each	7.0000	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>46231</div> <div>Loc Qty</div> <div>7</div> <div>7</div> <div>Loc Code</div>												
D3798-042RevA  Spacepod Floor		Manufactured	No			160	Each	2.0000	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>50351</div> <div>Loc Qty</div> <div>2</div> <div>2</div> <div>Loc Code</div>												

B53469 10-7-2009

10-7-2009

B53507 10-7-2009

October 22, 2009 1:59:24 PM

Shop Packet Print

Page 5

Picklist Print

October 22, 2009 1:59:24 PM

Page 6

Work Order ID: 53060

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH




Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
8 D3547-1RevA  Bracket		Manufactured	No			160	Each	22.0000	1.0000		10-7-238	
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>35455</div> <div>50260</div> <div>Loc Qty</div> <div>22</div> <div>8</div> <div>14</div> <div>Loc Code</div>												
8 D3550-1RevB  Strut		Manufactured	No			160	Each	17.0000	1.0000		10-7-228	
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>48367</div> <div>Loc Qty</div> <div>17</div> <div>17</div> <div>Loc Code</div>												
8 D3554-7RevA  Ball Stud		Manufactured	No			160	Each	60.0000	1.0000		10-7-228	
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>37674</div> <div>Loc Qty</div> <div>60</div> <div>60</div> <div>Loc Code</div>												

October 22, 2009 1:59:24 PM

Shop Packet Print

Page 6

Picklist Print

October 22, 2009 1:59:24 PM

Page 7

Work Order ID: 53060

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3015-3RevB

Manufactured

No

160

Each

328.0000

1.0000

Locknut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

128

43758

26

44446

49

48238

53

Main Warehouse

ST59

200

51711

200

AN3-3A

Purchased

No

160

Each

161.0000

4.0000

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

161

111925

11

112314

50

112720

100

B58002 10-7-0209

M114615 10-7-0209

October 22, 2009 1:59:24 PM

Shop Packet Print

Page 7

Picklist Print

October 22, 2009 1:59:24 PM

Page 8

Work Order ID: 53060

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S AN3-6A Bolt		Purchased	No			160	Each	135.0000	4.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>112082</div> <div>112513</div> <div>112720</div> <div>Loc Qty</div> <div>135</div> <div>7</div> <div>28</div> <div>100</div> <div>Loc Code</div>												
S AN3-10A Bolt		Purchased	No			160	Each	73.0000	2.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>111119</div> <div>Loc Qty</div> <div>73</div> <div>73</div> <div>Loc Code</div>												
S AN5-5A Bolt		Purchased	No			160	Each	107.0000	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>103585</div> <div>110363</div> <div>110865</div> <div>Loc Qty</div> <div>107</div> <div>3</div> <div>4</div> <div>100</div> <div>Loc Code</div>												

M113359 10-7-2009

M115016 10-7-2009

10-7-2009

October 22, 2009 1:59:24 PM

Shop Packet Print

Page 8

Picklist Print

October 22, 2009 1:59:24 PM

Page 9

Work Order ID: 53060

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH



Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN525-10R7  Screw		Purchased	No			160	Each	131.0000	38.0000			
<div>Warehouse Location</div> <div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div>Main Warehouse</div> <div>ST 131</div> <div>106166 30</div> <div>110844 15</div> <div>112314 10</div> <div>112411 76</div>												
MS24694-S67  Screw		Purchased	No			160	Each	103.0000	7.0000			
<div>Warehouse Location</div> <div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div>Main Warehouse</div> <div>ST 103</div> <div>101662 13</div> <div>106166 1</div> <div>111965 89</div>												

1113359 10-7-22 SP

10-7-22 SP

7

October 22, 2009 1:59:24 PM

Shop Packet Print

Page 9

Picklist Print

October 22, 2009 1:59:24 PM

Page 10

Work Order ID: 53060

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH




Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R14  Screw		Purchased	No			160	Each	937.0000	8.0000		10-7-2009	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>104916</div> <div>Loc Qty</div> <div>937</div> <div>937</div> <div>Loc Code</div>												
MS24694-S69  Screw		Purchased	No			160	Each	118.0000	1.0000		10-7-2009	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>103574</div> <div>110153</div> <div>112492</div> <div>Loc Qty</div> <div>118</div> <div>5</div> <div>13</div> <div>100</div> <div>Loc Code</div>												
A3235-020-935  Washer - Countersunk		Purchased	No			160	Each	694.0000	8.0000		10-07-21	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>104156</div> <div>106150</div> <div>Loc Qty</div> <div>694</div> <div>3</div> <div>691</div> <div>Loc Code</div>												

October 22, 2009 1:59:24 PM

Shop Packet Print

Page 10

Dart Aerospace Ltd

W/O: S3060		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-07-22		change route sequence SD on A3235-020-935 from 160 to 110		ET	10-07-22				
		permanent change		E	10-07-28				
10-07-22		add to pick list 02179 Backer plate permanent change		ET	10-07-22				
		pulled 02179 ^{x2} B35432 & ET 10-07-22		E	10-07-28				

Part No: D130-780-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date					

NOTE: Date & initial all entries

Picklist Print

October 22, 2009 1:59:24 PM

Page 11

Work Order ID: 53060

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149D0363J Purchased No



Washer

160

Each

2.0000

2.0000

14

M115107 10.7.22sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

112314

2

NAS1149D0332J Purchased No



Washer

160

Each

342.0000

16.0000

M113644 10.7.22sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

342

110625

16

110844

126

112794

200

NAS1149D0563J Purchased No



Washer

160

Each

100.0000

3.0000

M114752 10.7.22sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

100

112794

100

October 22, 2009 1:59:24 PM

Shop Packet Print

Page 11

Picklist Print

October 22, 2009 1:59:24 PM

Page 12

Work Order ID: 53060



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L3

Purchased

No

160

Each

3,430.000

46.0000

(22)

(1)

(15)



Nut



M114523

M114718

10.7.2008

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3430

110844

32

111274

35

111668

863

112314

2000

112385

500

MS21042L5

Purchased

No

160

Each

1,077.000

1.0000



Nut



M114813

10.7.2008

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1077

110382

10

111127

4

111636

63

112314

1000

October 22, 2009 1:59:24 PM

Shop Packet Print

Page 12

Picklist Print

October 22, 2009 1:59:24 PM

Page 13

Work Order ID: 53060

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AKS4-1032-130 Purchased No



Inserts ALS4 1032-130

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

6087

1

D130-780-013RevA Manufactured No



Switch Relocation

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

50272

2

M114407 107-22 SP

10-7-22 SP

October 22, 2009 1:59:24 PM

Shop Packet Print

Page 13

GENERAL NOTES:**1) MATERIALS:**

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLESFOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN**1. MOLD SCHEDULE:**

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

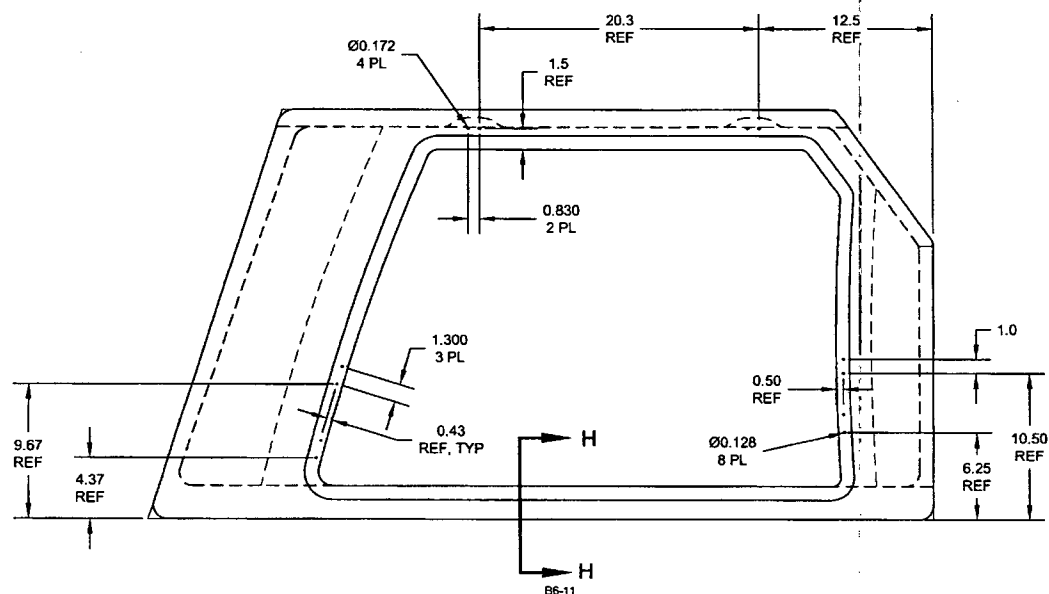
7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53060
BS 09-10-22**RELEASED**
2009-10-20
MP

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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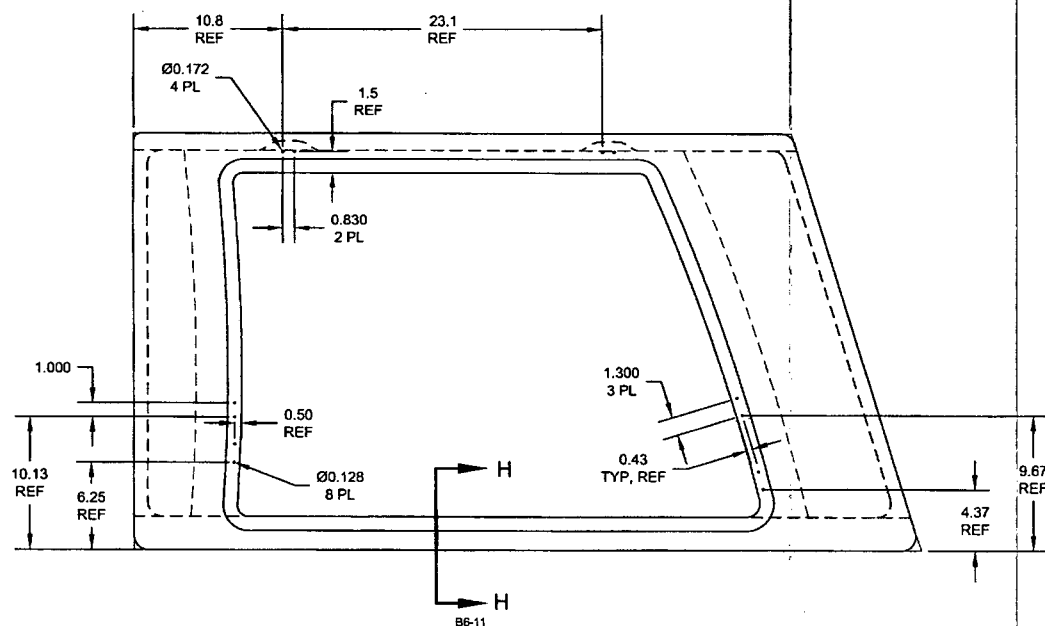


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1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV.
MFG. APPR.	RF	D3188	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
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D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

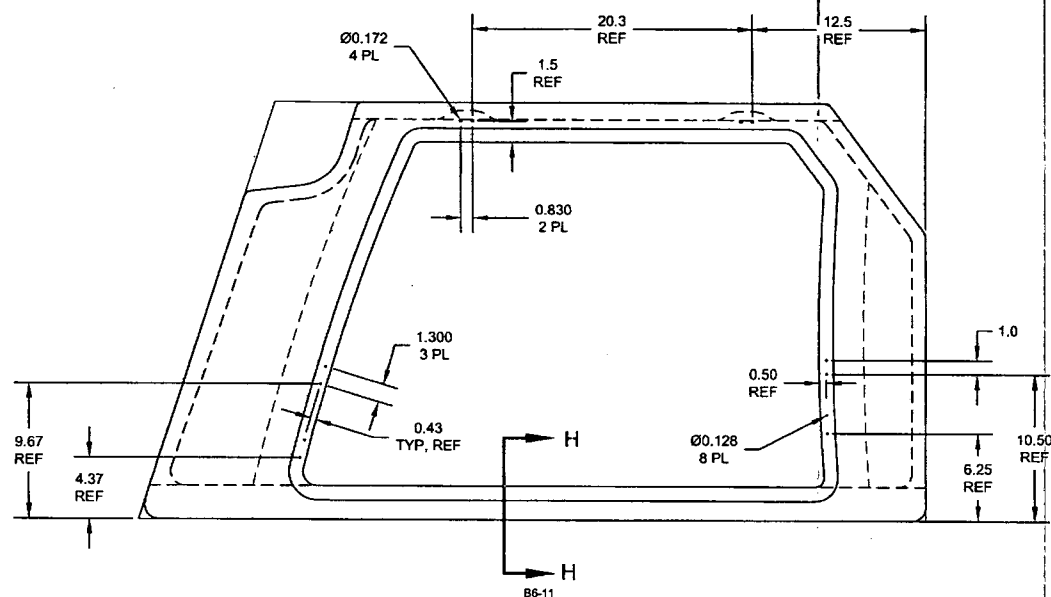
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

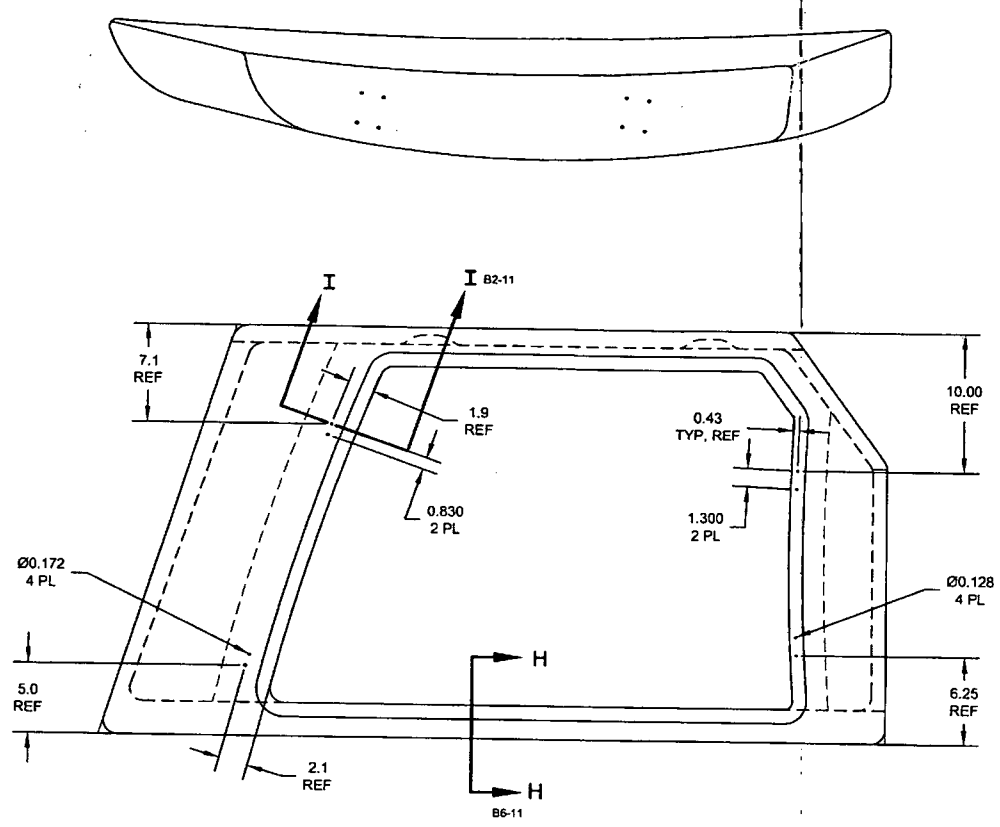
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 4 OF 11
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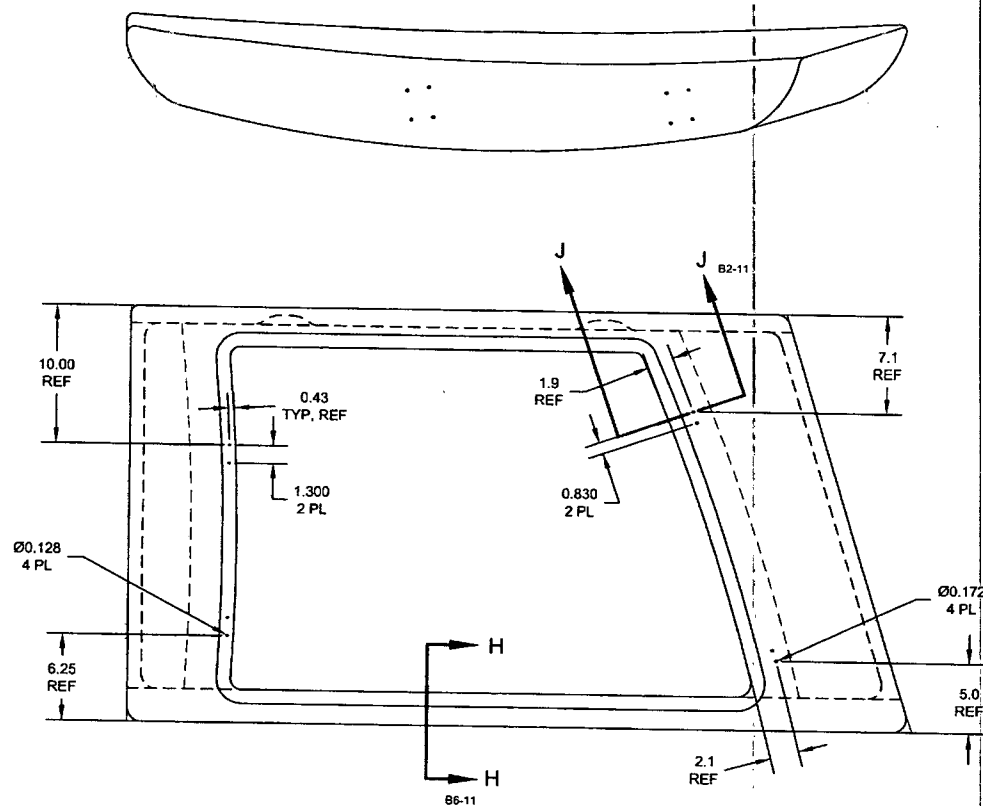


D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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MFG. APPR.	JB	D3188	SHEET 5 OF 11
APPROVED	JB	TITLE	SCALE
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D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

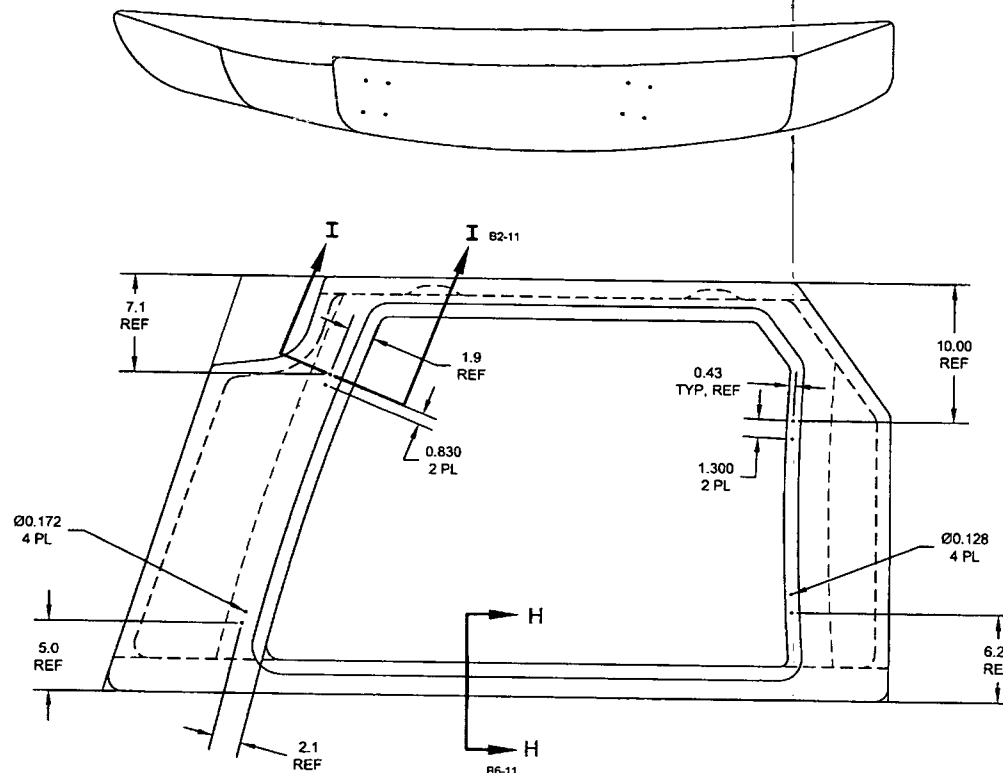
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 6 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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



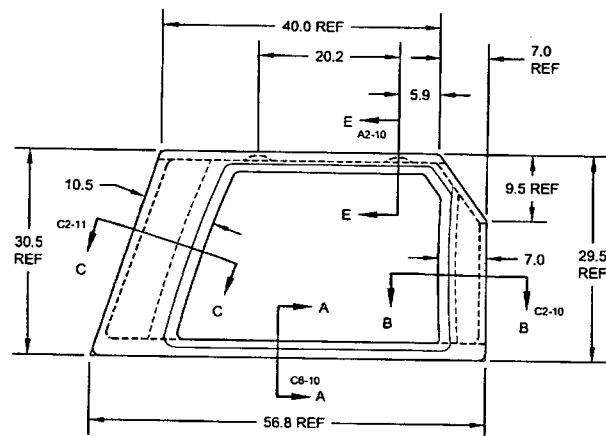
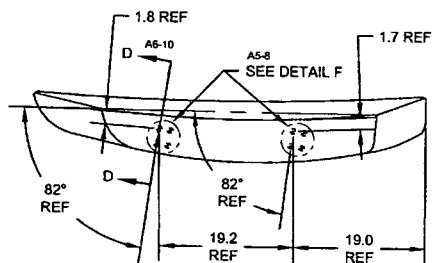
D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

NOTE:

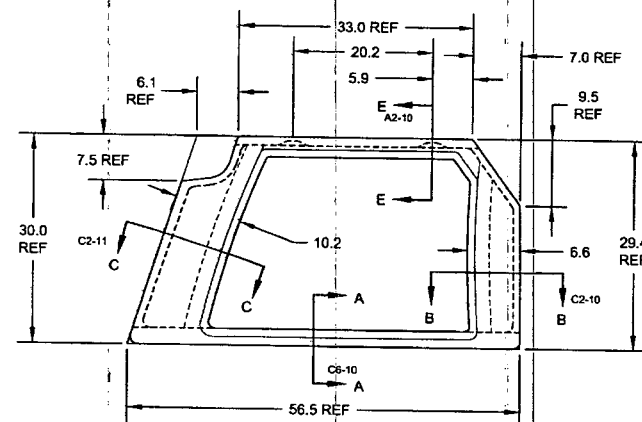
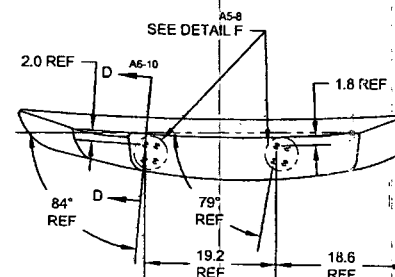
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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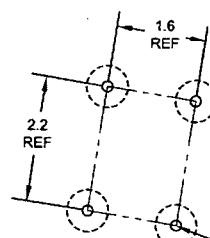
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 7 OF 11
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D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



DETAIL F





D3-8
D7-8

INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

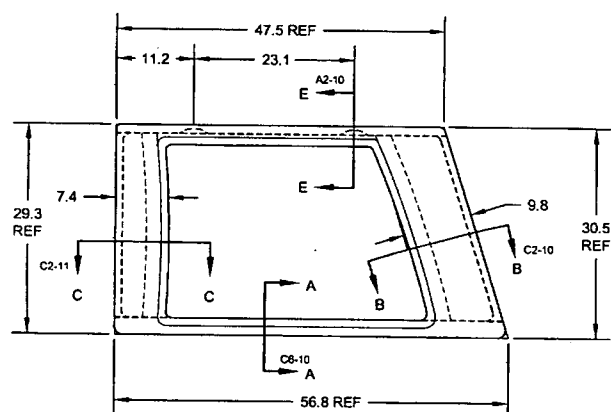
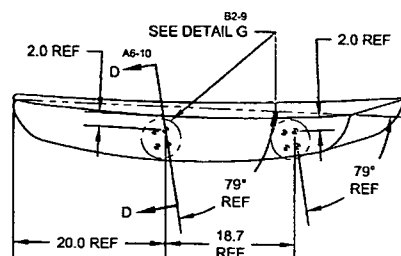
D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

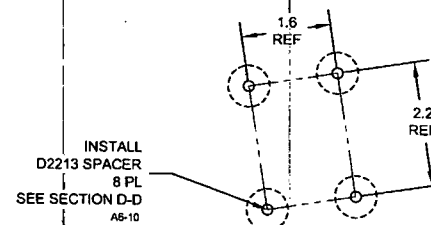
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2009-10-29

DESIGN	JB	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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D3188-2M SPACEPOD BODY







DETAIL G D6-8

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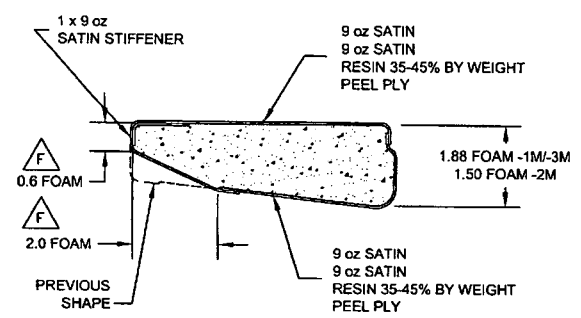
D3188-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

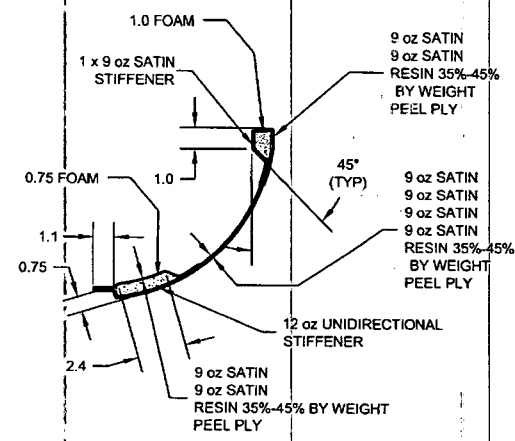
DESIGN	JB	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3188	SHEET 9 OF 11
APPROVED		TITLE	SCALE
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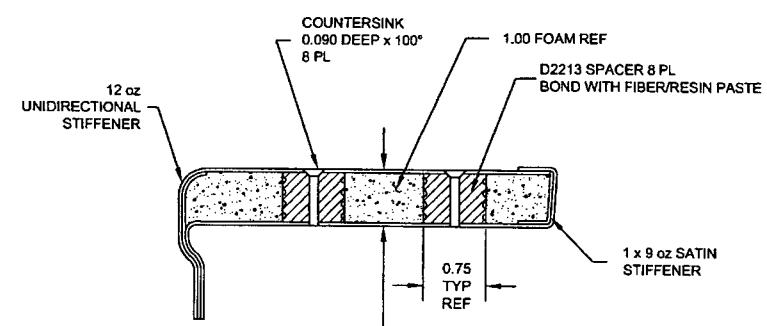
OUTBOARD



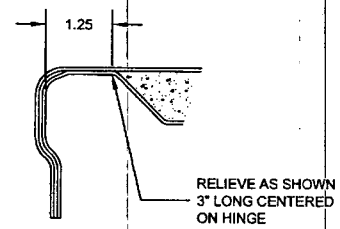
SECTION A-A
TYPICAL FLOOR SECTION
87-8
83-8
86-9



SECTION B-B
SECTION C-C OPPOSITE
86-8
88-8
84-8
82-8
87-8
85-9



SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS
D3-8
D7-8
D6-9

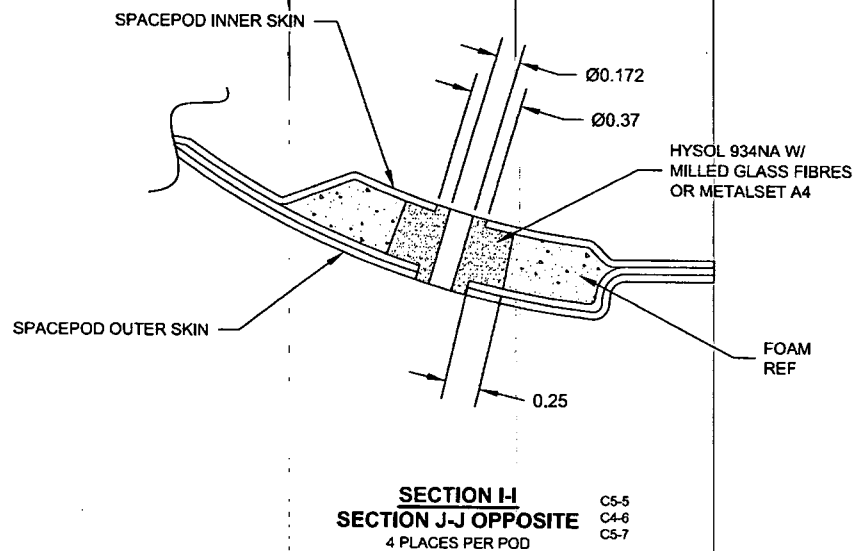
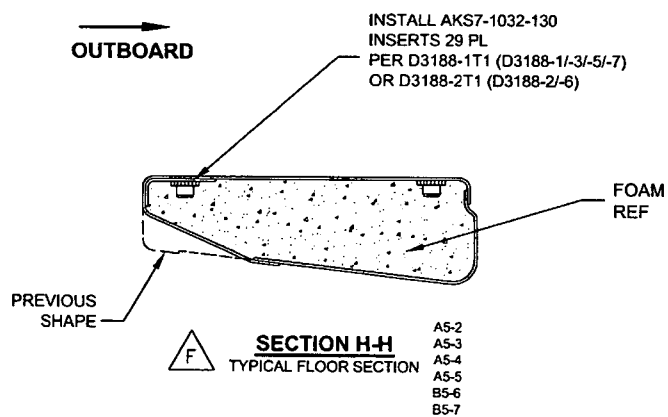


SECTION E-E
2 PLACES PER POD
C2-8
CT-8
86-8

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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 10 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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MFG. APPR.	#	D3188	SHEET 11 OF 11
APPROVED	#	TITLE	SCALE
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5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
	1		X				D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1				X		D130-780-013 /	SWITCH RELOCATION KIT
				1		X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	(3)						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1						D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
							D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1 /	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7 /	BALL STUD
4	4						AN3-3A /	BOLT
4	4						AN3-6A /	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A /	BOLT
38	38						AN525-10R7 /	SCREW
8	8						AN526C832R14 /	SCREW
6	(6)						MS24694S54	SCREW
7	7						MS24694S67 /	SCREW
1	1						MS24694S69 /	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J /	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J /	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3 /	NUT (or MS21042-3)
1	1						MS21042L5 /	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

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Revision: B
 Date: 09.06.11

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
					2		D3819-1	MALE SPADE CONNECTOR
					2		D3597-1	FEMALE SPADE CONNECTOR
					1		D3598-2-096	EXPANDABLE SLEEVE
					24		D3599-1	TIE-WRAP
					24		D3600-1	TIE-WRAP MOUNT
					24 FT		M22759/41-22-9	WIRE
		1*	1*				D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
	1**		1*				D3837-4	DECAL
		2*	2*				D2586	LATCH
		2*	2*				D2585	MOUNTING CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

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Revision: B
 Date: 09.06.11

REFERENCE

DART AEROSPACE LTD.

IIN-D130-780

Page 34 of 34

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
				2			NAS1149D0563J	WASHER
				1			D3892-1	SEAL
						1	D3983-1	OUTER CLOSEOUT
						1	D3983-3	INNER CLOSEOUT
						1	D3983-5	HINGE CLOSEOUT
						1	D3983-047	CLOSEOUT ATTACHMENT
						1	D3983-9	SPACER
						2	AN525-10R6	SCREW
						1	AN525-10R24	SCREW
						1	NAS1149D0363J	WASHER
						1	MS21042L3	NUT

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

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Revision: B

Date: 09.06.11

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D130-780 REV. B OR LATER APPROVED REVISION
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D130-780 REV. 1 OR LATER ACCEPTED REVISION

REF. TCCA STC: SH93-88
REF. FAA STC: SR00098NY
REF. EASA.IM.R.S.01292

REFER

The purpose of this DSI is to provide an alternate door prop for the D130-780-011 LH Sliding Door Hinge Kit.

In service experience has shown that LH Sliding Doors may have significantly more weight associated with their installation due to executive style finishing versus the standard utility LH Sliding Door. This extra weight requires a more powerful door prop to operate the door.

For D130-780-011 at CHG 003, the D3552-7 door prop is replaced with a D3552-13 door prop as follows:

IS

-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
				1			D3552-13	DOOR PROP

WAS

-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
				1			D3552-7	DOOR PROP

Customers with D130-780-011 at CHG 002 or earlier, may procure the DSI 9502-011 kit to replace the D3552-7 door prop with a D3552-13 door prop as follows:

-011		
X	DSI 9502-011	REPLACEMENT DOOR PROP KIT
1	D3552-13	DOOR PROP

- 1) Remove the D3552-7 door prop from the ball studs
- 2) Install the D3552-13 per IIN-D130-780 and ICA-D130-780.
- 3) Update parts list in IIN-D130-780 and ICA-D130-780 to reflect the part number change.
- 4) Make an entry in the technical record of the aircraft indicating that DSI 9502 has been accomplished.







Weight and Balance change associated with this DSI is negligible.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT-CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.02.03
CERT. NO.: SH93-88
ISSUE NO.: 6

A	NEW ISSUE		10.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9502	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT DOOR PROP	NTS
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